

Date: Wednesday, 1/11/2006 4:10:10 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L FLOAT STEP
Job Number	: 23320		
Estimate Number	: 10851		
P.O. Number	: N/A	Part Number	: D206628023
This Issue	: 1/11/2006 S.O. No. : N/A	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: N/A
Previous Run	: 25434	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 1/30/2006 Qty: 2 Um: Each
Checked & Approved By	: <u>SEE ABOVE USER & DATE</u>		
Comment	: Est Rev:D As Per Ecn766 06-01-06 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-023 CHG 002

DH 06/02/17

2.0	23320A	FLOAT STEP ASSEMBLY LH (206/407)
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Comment: Sub-Component D2842-041 Sub-Assembly
 FLOAT STEP ASSEMBLY LH (206/407)

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

4.0	D27317	Mounting Lug
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	D2731-7	Mounting Lug	B23331 ✓

5.0	D28441	Arm
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2844-1	Arm	B23332 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/11/2006 4:10:11 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FLOAT STEP

Job Number: 23320

Part Number: D206628023

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D28443	Arm
-----	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
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1	D2844-3	Arm	B314087
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7.0	D2856400	Abrasion Strip
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Comment: Qty.: 1.2660 f(s)/Unit Total : 2.5320 f(s)

Pick :

Qty	Part #	Description	Batch
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2	D2856-400 6.9"	Abrasion Strip	B24237B
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8.0	D3394043	LUG ASS'Y
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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4	D3394-043	LUG ASS,Y	B25468
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9.0	AN3C4A	BOLT
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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3	AN3C4A	Bolt	M19522
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10.0	AN4C12A	BOLT
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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4	AN4C12A	Bolt	M19600
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11.0	AN4C13A	BOLT
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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4	AN4C13A	Bolt	M19600
---	---------	------	--------

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: 206L FLOAT STEP

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Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN4C15A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C15A

Bolt

M1997

13.0

AN960C10



Comment: Qty.: 3.0000 EACH(s)/Unit Total : 6.0000 EACH(s)

Pick:

Qty Part Number

Description

Batch

3 AN960C10

WASHER

M18728

14.0

AN960JD416L

Washer,



Comment: Qty.: 24.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960JD416L Washer

M100229

15.0

NAS1515H4L

Inventory



Comment: Qty.: 24.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 NAS1515H4L

Washer

M18918

16.0

MS210434

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 MS21043-4

Nut (or MS21042-4)

M18535

17.0

NAS1515H3

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 NAS1515H3

Washer

M17944

206/3/9 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 2 Date: 8/13/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FLOAT STEP

Job Number: 23320

Part Number: D206628023

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

C 206/03/10

(2)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-023

Location: _____

PPP Rev: _____

F

9/13/10 E1

20.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

86/03/13

Job Completion



2 06-03-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	
Description: Float Step LH (206L/L1/L3/L4)		Part Number:	D206-628-023
Dwg:		Qty:	
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty																																																								
1	DC	Issue Travelers for: D206-628-023 Float Step LH D2842-041 Step Assembly LH																																																											
		<div>Batch</div> <div></div> <div></div>																																																											
2	DC	Photocopy bluefile and create labels per PPP D206-628-023 CHG001																																																											
3	ST	Pick: Packing Kit <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>4</td><td>D2731-5</td><td>Mounting Lug</td><td></td></tr><tr><td>4</td><td>D2731-7</td><td>Mounting Lug</td><td></td></tr><tr><td>1</td><td>D2842-041</td><td>Step Assembly LH</td><td></td></tr><tr><td>2</td><td>D2844-1</td><td>Arm</td><td></td></tr><tr><td>1</td><td>D2844-3</td><td>Arm</td><td></td></tr><tr><td>3</td><td>AN3-4A</td><td>Bolt</td><td></td></tr><tr><td>4</td><td>AN4-11A</td><td>Bolt</td><td></td></tr><tr><td>4</td><td>AN4-12A</td><td>Bolt</td><td></td></tr><tr><td>4</td><td>AN4-13A</td><td>Bolt</td><td></td></tr><tr><td>3</td><td>AN960JD10</td><td>Washer</td><td></td></tr><tr><td>12</td><td>AN960JD416</td><td>Washer</td><td></td></tr><tr><td>12</td><td>MS21042L4</td><td>Nut (or -4)</td><td></td></tr><tr><td>1</td><td colspan="2">Copy of paperwork from step 2</td><td></td></tr></tbody></table>	Qty	Part Number	Description	Batch	4	D2731-5	Mounting Lug		4	D2731-7	Mounting Lug		1	D2842-041	Step Assembly LH		2	D2844-1	Arm		1	D2844-3	Arm		3	AN3-4A	Bolt		4	AN4-11A	Bolt		4	AN4-12A	Bolt		4	AN4-13A	Bolt		3	AN960JD10	Washer		12	AN960JD416	Washer		12	MS21042L4	Nut (or -4)		1	Copy of paperwork from step 2					
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4	QC4	Inspect Kit 100% for Completeness on the W/O																																																											
5	PK	Identify and pack for shipping as per PPP D206-628-023																																																											
6	AC	Cost / part: _____																																																											
7	DC	Close W/Order and Ensure Travellers Attached Inspect Level 21 Travellers: D206-628-023 D2842-041																																																											

Rev	Date	Change	Revised By	Approved
A	99.05.05	New Issue	DM	
B	04.05.17	Reformat; Added D2842-041 as traveler	KJ/JLM	

REFERENCE ONLY